



U.S. Department
of Transportation
**Research and
Special Programs
Administration**

400 Seventh St., S.W.
Washington, D.C. 20590

OCT 18 2001

DOT-E 8561
(SECOND REVISION)

EXPIRATION DATE: January 31, 2002

(FOR RENEWAL, SEE 49 CFR § 107.109)

1. GRANTEE: Pacific Scientific Company
Duarte, CA
2. PURPOSE AND LIMITATIONS:
 - a. This exemption authorizes the manufacture, mark, sale and use of a non-DOT specification cylinder conforming with all regulations applicable to a DOT specification 3HT cylinder, except as specified herein, for the transportation in commerce of the materials authorized by this exemption. This exemption provides no relief from any Hazardous Materials Regulation (HMR) other than as specifically stated herein.
 - b. The safety analyses performed in development of this exemption only considered the hazards and risks associated with transportation in commerce.
3. REGULATORY SYSTEM AFFECTED: 49 CFR Parts 106, 107 and 171-180.
4. REGULATIONS FROM WHICH EXEMPTED: 49 CFR §§ 173.304(a)(1) and 175.3 in that a non-DOT specification cylinder is not authorized, except as specified herein.
5. BASIS: This exemption is based on the application of Pacific Scientific Company dated December 8, 1999, submitted in accordance with § 107.109 and supplemental information dated September 18, 2001,.

6. HAZARDOUS MATERIALS (49 CFR § 172.101):

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Proper Shipping Name/ Hazardous Material Description	Hazard Class/ Division	Identi- fication Number	Packing Group
Oxygen, compressed	2.2	UN1072	n/a

7. SAFETY CONTROL MEASURES:

a. PACKAGING - Packaging prescribed is a non-DOT specification girth welded stainless steel cylinder having 25 cubic inches maximum water capacity and 2200 psi maximum service pressure, manufactured in compliance with HTL Industries' drawing 32197800 dated December 18, 1980, on file with the Office of Hazardous Materials Exemptions and Approvals (OHMEA) and DOT specification 3HT, except as follows:

§ 178.35(e) *Safety relief devices.*

Applies except that a statement verifying the adequacy of the pressure relief devices for each cylinder design must be submitted to the OHMEA prior to initial shipment.

§ 178.44(a) *Type, size and pressure.*

Girth welded stainless steel cylinders with 2 end fittings welded as shown on the drawing not over 25 cubic inches water volume and a service pressure of 2,200 pounds per square inch.

§ 178.44(b) *Authorized Material.*

Type ARMCO Nitronic 40 (21-6-9) stainless steel with the following analysis is authorized with proper welding procedure.

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<u>CHEMICAL ANALYSIS</u>	<u>PERCENT</u>
Carbon	0.040 max.
Manganese	8.00/10.00
Phosphorus	0.060 max.
Sulfur	0.030 max.
Silicon	1.00 Max.
Chromium	19.00/21.50
Nickel	5.50/7.50
Nitrogen	0.15/0.40

§ 178.44(d) *Manufacture.*

(Added) Each cylinder shall be subjected to a process treatment after welding and before stress relieving by hydrostatically pressurizing to at least 100 percent but not more than 110 percent of the test pressure, and maintained at this pressure for 3 minutes. The process treatment must be witnessed by the independent inspector.

§ 178.44(e) *Welding or Brazing.*

(Added) Welding as prescribed in § 178.44(d) of this exemption is authorized. All pressure welds shall be 100 percent radio-graphed after hydrostatic test.

§ 178.44(f) *Wall thickness.*

(1) Minimum wall thickness for any cylinder must be 0.050 inch. The minimum wall thickness must be such that the wall stress at the minimum specified test pressure shall not exceed 120,000 psi.

* * *

§ 178.44(g) *Heat treatment.*

The half cylinders may be stress relieved or annealed for forming. Welded cylinders must be stress relieved at a temperature of 900 °F. ± 25° for one hour. Stress relieving to be done after process treatment and before hydrostatic test.

§ 178.44(j) *Cycling test.*

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* * *

(1) * * *

(2) Results of design qualification testing per § 178.44(p)(4) of this exemption must be submitted to the OHMEA prior to initial shipment. Cycle test on each lot is not required.

(3) A lot is defined as group of cylinders sequentially produced from the same heat of steel, manufactured by the same process and stress relieved in the same equipment under the same conditions of time temperature and atmosphere and shall not exceed a quantity of 200 cylinders.

(4) * * *

§ 178.44(m) *Physical tests.*

Not required.

§ 178.44(n) *Magnetic particle inspection.*

Not required. Instead, of each cylinder must be inspected using apparatus and procedures for liquid penetrant examination in accordance with ASTM E-165-65. Inspection shall be performed externally on the finished cylinder after hydrostatic test. Evidence of discontinuities, which in the opinion of the independent inspector may appreciably weaken or decrease the durability of the cylinder, shall be cause of rejection.

§ 178.44(p) *Acceptable results of tests.*

(1) Flattening required without cracking to six times the wall thickness of the cylinder.

(2) Physical tests: Not required.

(3) Burst pressure shall be at least 4/3 times the test pressure. Failure must initiate in the sidewall of the cylinder in a longitudinal direction. Actual burst pressure must be recorded.

(4) Cycling: The design must be qualified by cycling 3 cylinders from zero to service pressure to at least 50,000 pressurizations without evidence of distortion or failure.

§ 178.44(q) *Rejected cylinders.*

Repair of welded seams by welding prior to process treatment authorized; subsequent thereto cylinders must be heat treated and pass all prescribed tests.

§ 178.44(r) *Marking.*

Applies except that instead of DOT-3HT, cylinders must be marked DOT-E 8561 followed by the service pressure. Stamping of elastic expansion is not required.

§ 178.44(s) *Inspectors Report.*

(Add) Inspectors report must be appropriately modified to reflect identification and compliance with this exemption.

b. TESTING - Each cylinder must be reinspected and hydrostatically retested every 3 years in accordance with § 173.34(e) as prescribed for DOT-3HT cylinders except that the rejection elastic expansion does not apply.

c. OPERATIONAL CONTROL - The pressure vessels are authorized for transportation when equipped with actuating cartridges installed in the discharge outlet. The actuating cartridges must be approved by the Associate Administrator for Hazardous Materials Safety.

8. SPECIAL PROVISIONS:

a. In accordance with the provisions of Paragraph (b) of § 173.22a, persons may use the packaging authorized by this exemption for the transportation of the hazardous materials specified in paragraph 6, only in conformance with the terms of this exemption.

b. A person who is not a holder of this exemption, but receives a package covered by this exemption, may reoffer it for transportation provided no modifications or changes are made to the package and it is offered for transportation in conformance with this exemption and the HMR.

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- c. A current copy of this exemption must be maintained at each facility where the package is offered or reoffered for transportation.
- d. Each packaging manufactured under the authority of this exemption must be marked with a registration symbol designated by the Office of Hazardous Materials Exemptions and Approvals for a specific manufacturing facility.
- e. A current copy of this exemption must be maintained at each facility where the package is manufactured under this exemption. It must be made available to a DOT representative upon request.
- f. Cylinders are limited to use in military weapons systems only. A copy of the inspector's report on the first lot of cylinders produced must be submitted to the OHMEA prior to initial shipment.
- g. Cylinders must be shipped in strong outside packagings in conformance with § 173.301(k).
- h. A cylinder is not authorized 15 years from the date of manufacture.
9. MODES OF TRANSPORTATION AUTHORIZED: Motor vehicle, rail freight, cargo aircraft only.
10. MODAL REQUIREMENTS: A current copy of this exemption must be carried aboard each aircraft used to transport packages covered by this exemption. The shipper shall furnish a copy of this exemption to the air carrier before or at the time the shipment is tendered.
11. COMPLIANCE: Failure by a person to comply with any of the following may result in suspension or revocation of this exemption and penalties prescribed by the Federal hazardous materials transportation law, 49 U.S.C. 5101 et seq:
- o All terms and conditions prescribed in this exemption and the Hazardous Materials Regulations, Parts 171-180.
 - o Registration required by § 107.601 et seq., when applicable.

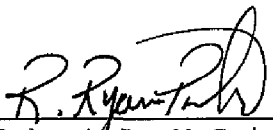
Each "Hazmat employee", as defined in § 171.8, who performs a function subject to this exemption must receive training on the requirements and conditions of this exemption in

addition to the training required by §§ 172.700 through 172.704.

No person may use or apply this exemption, including display of its number, when the exemption has expired or is otherwise no longer in effect.

12. REPORTING REQUIREMENTS: The carrier is required to report any incident involving loss of packaging contents or packaging failure to the Associate Administrator for Hazardous Materials Safety (AAHMS) as soon as practicable. (Sections 171.15 and 171.16 apply to any activity undertaken under the authority of this exemption.) In addition, the holder(s) of this exemption must also inform the AAHMS, in writing, as soon as practicable of any incidents involving the package and shipments made under this exemption.

Issued at Washington, D.C.


For Robert A. McGuire
Associate Administrator for
Hazardous Materials Safety

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(DATE)

Address all inquiries to: Associate Administrator for Hazardous Materials Safety, Research and Special Programs Administration, Department of Transportation, Washington, D.C. 20590.
Attention: DHM-31.

The original of this exemption is on file at the above office. Photo reproductions and legible reductions of this exemption are permitted. Any alteration of this exemption is prohibited.

Copies of exemptions may be obtained from the AAHMS, U.S. Department of Transportation, 400 7th Street, S.W., Washington, DC 20590-0001, Attention: Records Center, 202-366-5046.

PO: KFW